

Work Order ID 60196

Monday, June 28, 2010 3:20:02 PM



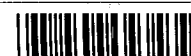
Page 1

Item ID: D2282-041

Accept



Setup Start



Revision ID:

Stop



Item Name: T Assembly

Start Date: 6/28/2010 Start Qty: 40.00



Cust Item ID:

Required Date: 7/5/2010 Req'd Qty: 40.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

PL

Date: 10-6-09

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D2282	Rev E
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100		0.00							
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Large Fab

Large Fab

Memo

0.00

Large Fab

I-Weld as per D2282-041 'T' Handle Assembly
Grind chamfers and ensure full penetration as per dwg D2282
*****brush weld right after welding, to take color off *****
A/RER316L SS Filling Rod M109160

EL 10-7-5 X38

110		0.00							
-----	--	------	--	--	--	--	--	--	--



QC9- Inspect visual per QSI004- Fusion Welds

QC

Memo

0.00

Quality Control

PL 10-07-05

120		0.00							
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Small Fab

Small Fab

Memo

0.00

Small Fab

Tumble

SAD 10-07-08 counted 38

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60196

Monday, June 28, 2010 3:20:02 PM

Page 2

Item ID: D2282-041

Accept

Revision ID:

Item Name: T Assembly

Start Date: 6/28/2010 Start Qty: 40.00

Required Date: 7/5/2010 Req'd Qty: 40.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Setup

Start

Stop

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S 5/6/2/02

38

count

140

Identify as per dwg & Stock Location 261

0.00



Packaging

Memo

0.00

Packaging

10-7-8 SD

38

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

MF 10-7-8

Dart Aerospace Ltd

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Picklist Print

Monday, June 28, 2010 3:20:06 PM

Page 1 / 1

Work Order ID: 60196



Parent Item: D2282-041



Parent Item Name: T Assembly

Start Date: 6/28/2010

Required Date: 7/5/2010

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev:A Removed from 9 Digit 05-12-02 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2282-3 Tube		Manufactured	No			100	Each	38.0000	1	40			
<div> <div>Location</div> <div>WA</div> <div>51725</div> <div>56688</div> </div> <div> <div>Loc Qty</div> <div>38</div> <div>20</div> <div>18</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													
D2282-5 Tube		Manufactured	No			100	Each	62.0000	1	40			
<div> <div>Location</div> <div>ST261</div> <div>51726</div> <div>56689</div> </div> <div> <div>Loc Qty</div> <div>62</div> <div>42</div> <div>20</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													

EL 10-7-5

20
18

EL 10-7-5

18
20

W/O:		WORK ORDER CHANGES						
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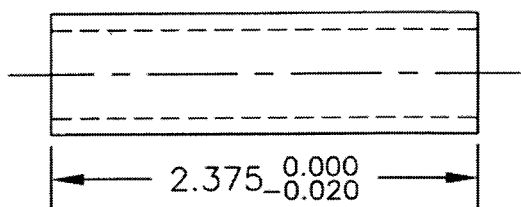
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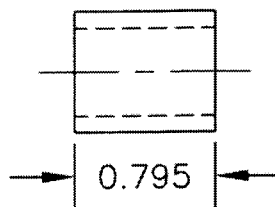


DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	

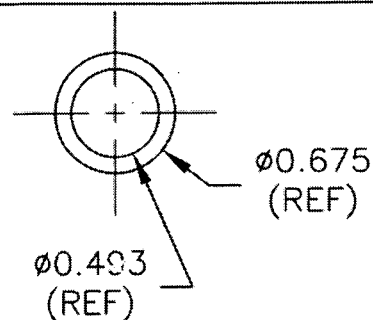
RELEASED
[Signature]
05/09/16



D2282-3

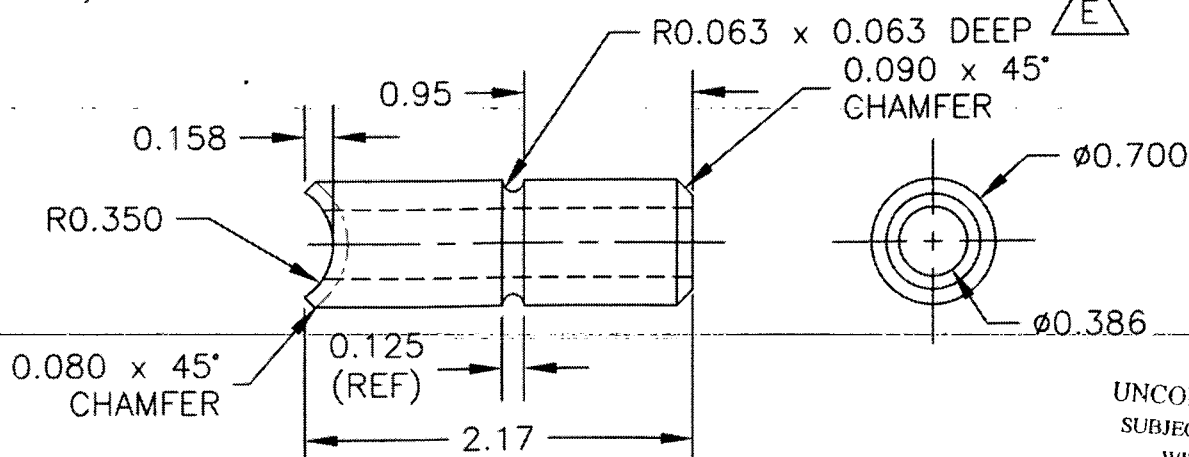


D2282-7



D2282-3/-7 TUBE:

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2282-5

D2282-5 STEM:

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *[Signature]*

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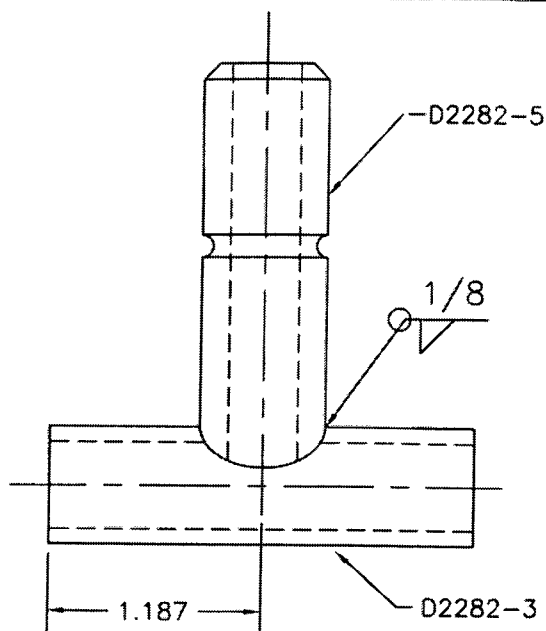
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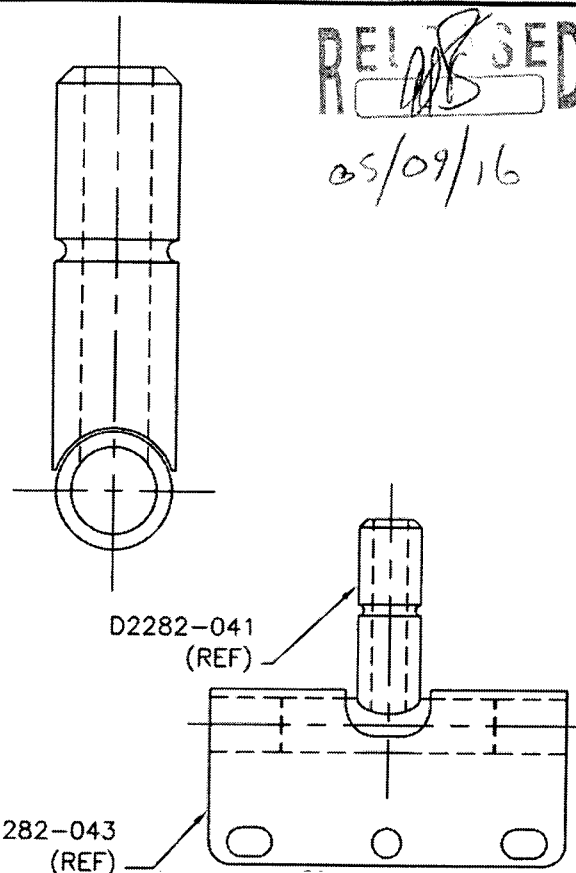
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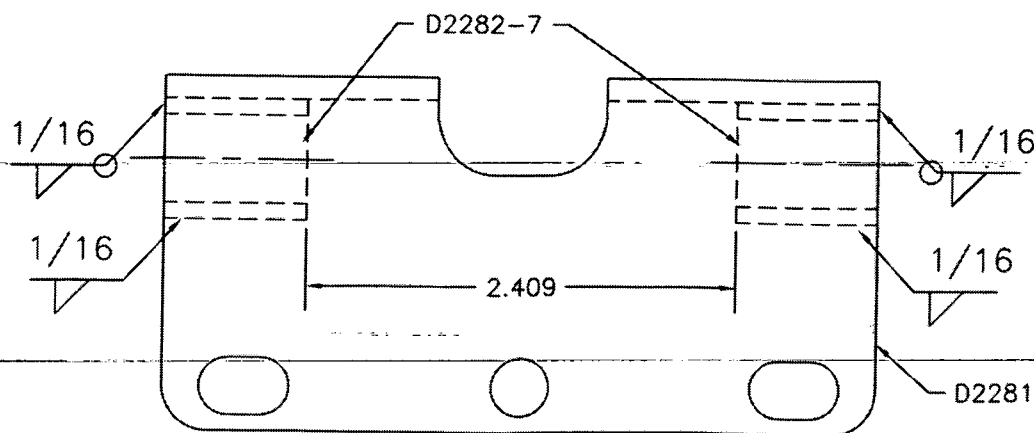
DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>UP</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07	TITLE HANDLE TUBES		SCALE 1:1



D2282-041 'T' ASSEMBLY
WELD ASSEMBLY PER DART QSI 004



GENERAL ASSEMBLY
SCALE 1:2



D2282-043 SADDLE ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

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